

Work Order ID 85094

June-01-12 3:42:44 PM

85094

Page 1

Item ID: D350-578-021

Accept

Revision ID:

Item Name: Bearpaw

Start Date: 01/06/2012 Start Qty: 4.00 ***4***Required Date: 15/06/2012 Req'd Qty: 4.00 ***4***

Reference:

Approvals: Process Plan: MLJ Date: 12/06/04 Tooling:
 QC: Date: SPC (Y/N):

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D2672	Rev B1
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100	DOCUMENT CONTROL	0.00
-----	------------------	------

100	Memo	0.00
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DC	Photocopy bluefile and create labels per PPP D350-578-021 CHG005	<i>DAS 12/06/13</i>
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Document Control		
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160	Packaging	0.00
-----	-----------	------

160	Memo	0.00
--------------	------	------

Packaging	Pick: Packing Kit	
-----------	-------------------	--

	(Note: D2672B is on the BOM as material from step 3)	
--	--	--

170	QC4- 100% Inspect kits for completeness	0.00
-----	---	------

170	Memo	0.00
--------------	------	------

QC		
----	--	--

Quality Control		
-----------------	--	--

N900040100Setup Start ***NS1***Stop ***NS2***Run Start ***NR1***Stop ***NR2***

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D350-578-021

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Bearpaw

Stop

NS2

Start Date: 01/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 15/06/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

180

Packaging

Packaging

0.00

Identify and pack for shipping as per PPP D350-578-021
Identify and Stock
Location: *New*

190

190

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*PPM 12/17/12**12/17/12**MF**12-07-13*

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NOTE: Date & initial all entries

Picklist Print

Page 1

June-01-12 3:42:48 PM

Work Order ID: 85094

85094
D350-578-021

Parent Item: D350-578-021

Parent Item Name: Bearpaw

Start Date: 01/06/2012

Required Date: 15/06/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-01-02 JLM
IPP Rev:B New Manufacturing Method 08-10-29 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2672		Manufactured	No			100	Each	1.0000	25	8	85097	JB	Spa

Su *D2672*
Bearpaw 13" X 24", 206

Location	Loc Qty	Loc Code
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ST495	1	
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73110	1	
-------	---	--

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AN4-17A	Purchased	No	Location	Loc Qty	Loc Code
			ST358	300	

AN4-17A	Bolt	Purchased	No	Location	Loc Qty	Loc Code
				ST358	300	

AN4-17A	Bolt	Purchased	No	Location	Loc Qty	Loc Code
				ST358	300	

AN4-17A	Bolt	Purchased	No	Location	Loc Qty	Loc Code
				ST358	300	

AN4-17A	Bolt	Purchased	No	Location	Loc Qty	Loc Code
				ST358	300	

AN4-17A	Bolt	Purchased	No	Location	Loc Qty	Loc Code
				ST358	300	

AN4-17A	Bolt	Purchased	No	Location	Loc Qty	Loc Code
				ST358	300	

AN4-17A	Bolt	Purchased	No	Location	Loc Qty	Loc Code
				ST358	300	

AN4-17A	Bolt	Purchased	No	Location	Loc Qty	Loc Code
				ST358	300	

AN960JD416	NAS1149D0463J	Purchased	No	Location	Loc Qty	Loc Code
				ST351	30	

AN960JD416	NAS1149D0463J	Purchased	No	Location	Loc Qty	Loc Code
				ST351	30	

AN960JD416	NAS1149D0463J	Purchased	No	Location	Loc Qty	Loc Code
				ST351	30	

AN960JD416	NAS1149D0463J	Purchased	No	Location	Loc Qty	Loc Code
				ST351	30	

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

June-01-12 3:42:48 PM

Work Order ID: 85094

Parent Item: D350-578-021

Parent Item Name: Bearpaw

85094
D350-578-021

Start Date: 01/06/2012

Required Date: 15/06/2012

Start Qty: 4.00

Required Qty: 4.00

D2182B

Manufactured No

160

f

128.5952

2.5

10

**

D2182B

Rubber Cushion

S+4
→ released
S12/07/10

(D2182B050) 6 X 5.00" PER KIT

D2274

Manufactured No

160

Each

623.0000

12 48

**

S+4 *D2274*

Radius Block

S+4 D2438
12/07/13

Manufactured No

160

Each

84.0000

6 24

**

86871

JB 12/07/10

Location	Loc Qty	Loc Code
ST410	128.59517	
63413	1.6	
66063	41.61817	
73932	85.377	73932

Location	Loc Qty	Loc Code
ST007	623	
78233	2	
81958	160	
83258	210	
84199	251	84199

Location	Loc Qty	Loc Code
ST456	84	
77038	6	
83265	28	
83266	50	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 85094

85094

Parent Item: D350-578-021

D350-578-021

Parent Item Name: Bearpaw

Start Date: 01/06/2012

Required Date: 15/06/2012

D2529

D2529
Washer

Manufactured No 160 Each 761.0000

12/06/12 48

**

Required Qty: 4.00

Start Qty: 4.00

Required Qty: 4.00

Location	Loc Qty	Loc Code
ST010	761	
79485	18	
81873	243	
84435	500	

MS2104214

MS2104214
Nut

Purchased No 160 Each 3,910.0000

12/06/12 48

**

JB 12/07/10

Location	Loc Qty	Loc Code
ST300	3910	
119075	116	
121011	537	
121444	2957	
121652	300	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 85094 M7M 12/06/04

DART



DESIGN *KE* DRAWN BY *KE* DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
REV. B

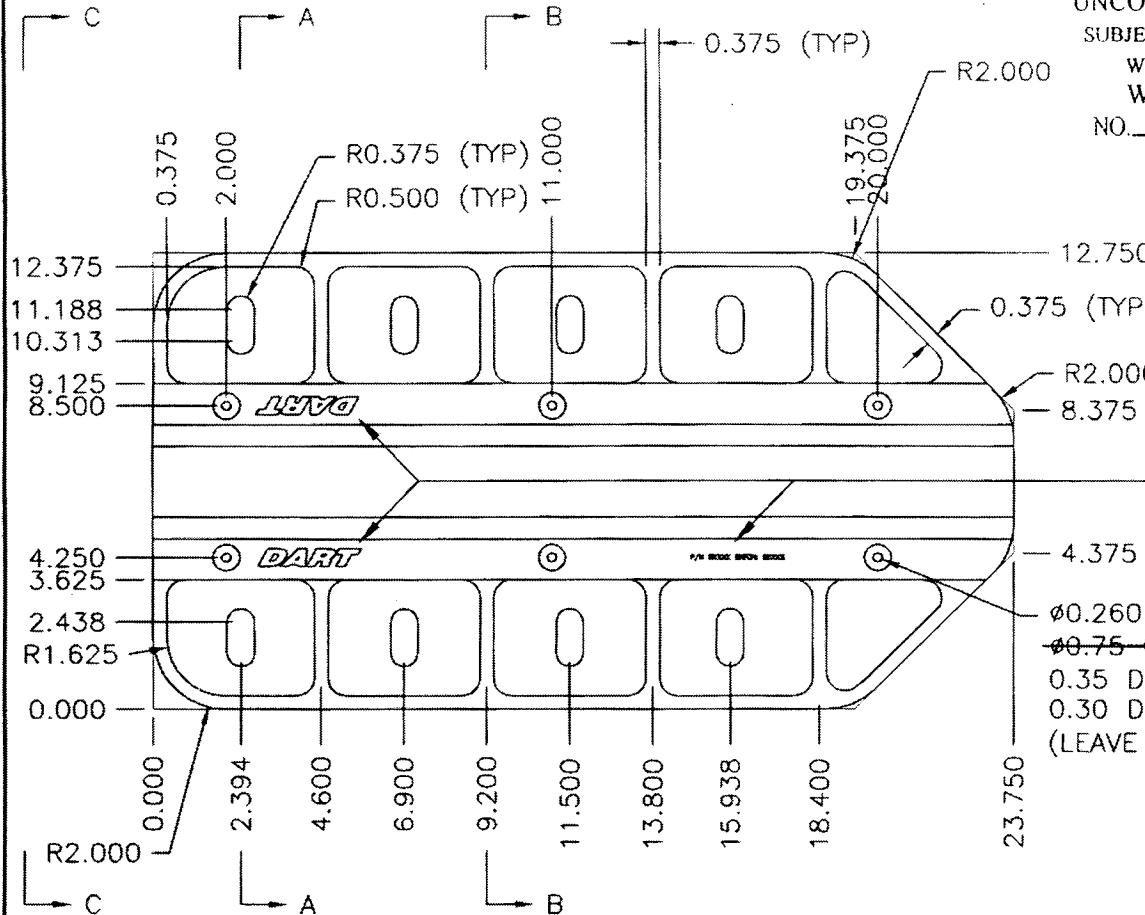
CHECKED *WV* APPROVED *WV* DRAWING NO. D2672
DATE 98.05.19 TITLE BEARPAW

SHEET 1 OF 2
SCALE 1:5

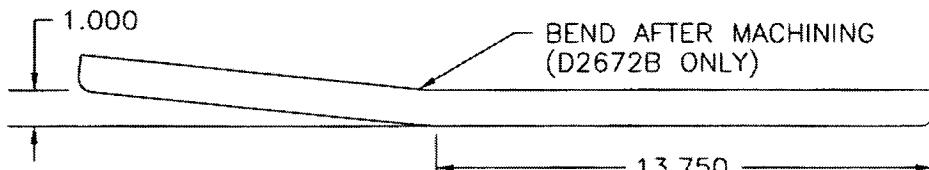
A	97.04.08	NEW ISSUE
B	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50 <i>WV</i> OR. 10.22 ϕ 0.93 WAS ϕ 0.75

RELEASED
q3.06.12 KE

EFFECTIVE	DEOS
<i>q3.06.12</i>	



FLAT PATTERN



D2672F: FLAT BEARPAW
D2672B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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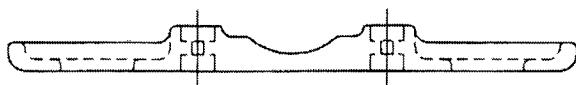
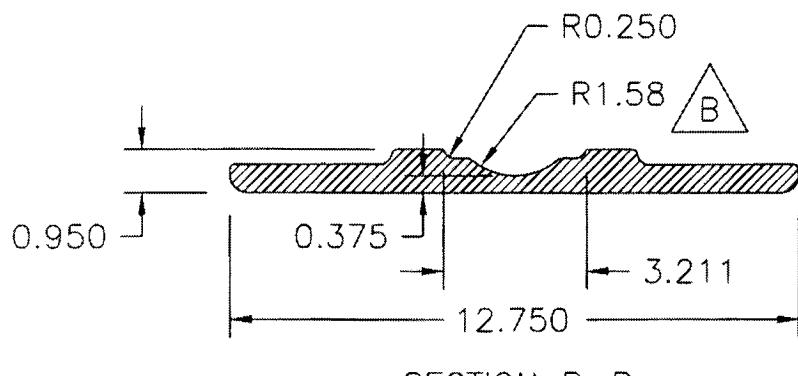
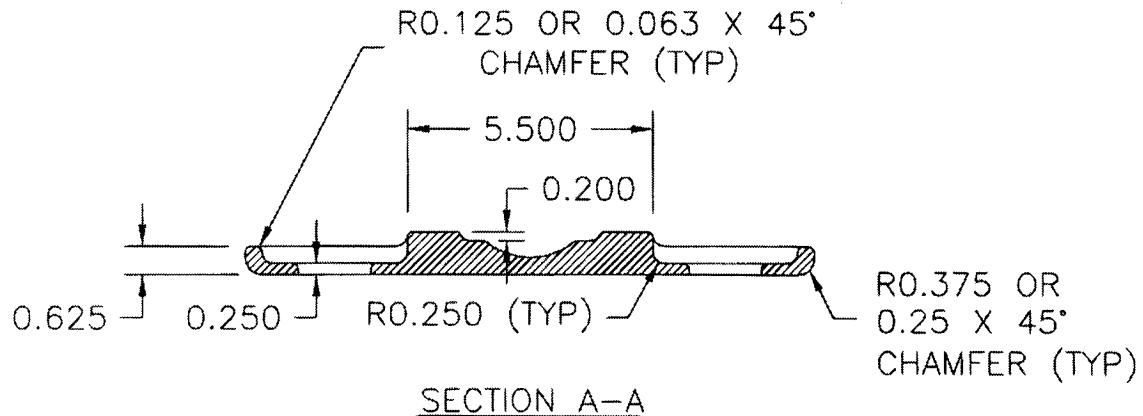
NOTE: Date & initial all entries

DART



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2672
DATE 98.05.19	TITLE	REV. B SHEET 2 OF 2 SCALE 1:4

RELEASED
99.06.17 KE



SECTION C-C

16058

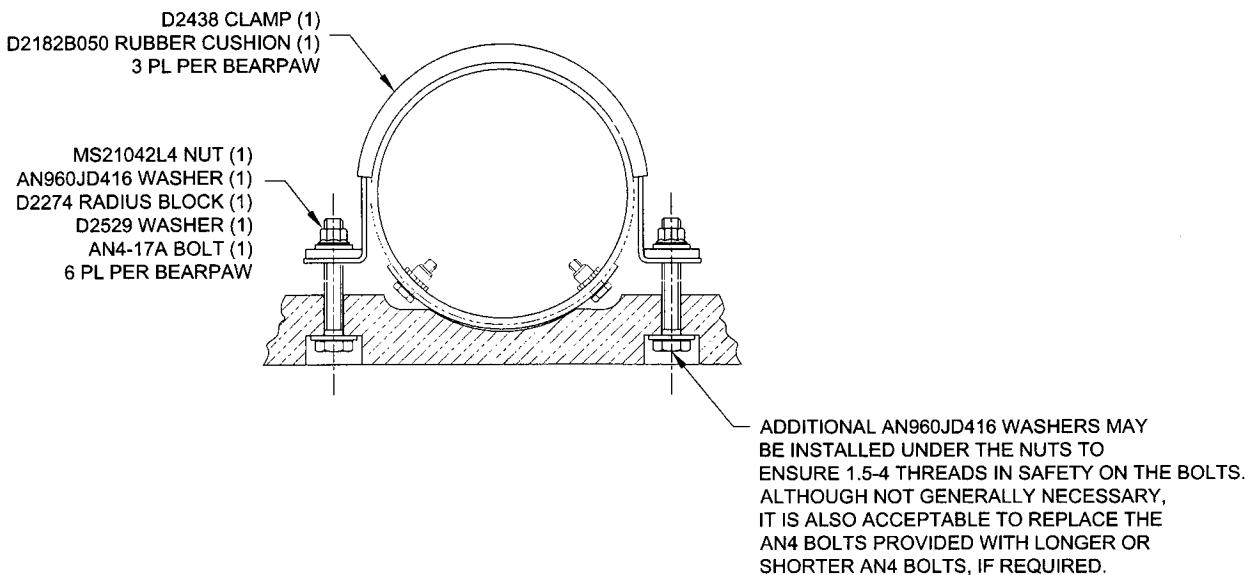
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Section A-A
Figure 4 – Clamping Detail

5.0 PARTS LIST

Qty -011	Qty -021	Part Number	Description
X		D350-578-011	BEARPAW INSTALLATION
	X	D350-578-021	BEARPAW INSTALLATION
6	6	D2182B050	Rubber Cushion
12	12	D2274	Radius Block
12	12	D2529	Washer
6	6	D2438	Clamp
2		D2432F	Bearpaw
	2	D2672F	Bearpaw
12	12	AN4-17A	Bolt
24	24	AN960JD416	Washer
12	12	MS21042L4	Nut (or MS21042-4)

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Revision: F
Date: 08.08.28